

Date: Tuesday, 19/08/2008 4:05:06 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLEVIS
 Job Number : 41459
 Estimate Number : 11301
 P.O. Number :
 This Issue : 19/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : MACHINED PARTS
 Previous Run : 41221
 Part Number : D34475
 Drawing Number : D3447REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 18/09/2008 Qty: 15 Um: Each
 Written By :
 Checked & Approved By : JUL 08-8-19
 Comment : A A 05.08.26 New issue KJ/JLM
 Est Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R1000 ROUND BAR 1.00"



Comment: Qty.: 0.3325 f(s)/Unit Total : 3.3254 f(s)
 ROUND BAR 1.00"
 Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6R1.000)
 Identify for D3447-5
 Batch: M 104554

20 08/08/25

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: DOOSAN CNC LATHE
 Turn as per Folio & Dwg B67-43001 Dwg Rev: _____

20 08/08/28

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/08/28

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL LATHE
 Drill as per Dwg D3447
 Deburr

Tools: rill

20 08/08/28

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:05:06 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 41459

Part Number: D34475

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SS 08/08/29 (15)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FL 08/09/02 (15)

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3
Mask 0.875" round section

M102316

(15X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00
320 °C
10:30

M-F 08/09/13

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/09/15 (15)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 129

P-8/9/15 (15)

11.0	QC21	FINAL INSPECTION W/O RELEASE
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Comment: FINAL INSPECTION W/O RELEASE

Job Completion



MF 08-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41459
Description: Clevis		Part Number: D3447-5
Inspection Dwg: D3447	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.78	+/-0.030	3.78	✓			
2.500	+/-0.010	2.500	✓			
Ø0.859	+0.000/-0.005	.859	✓			
10°	+/-0.5°	10°	✓			
0.380	+/-0.010	.380	✓			
0.190	+/-0.010	.190	✓			
0.442	+/-0.010	.442	✓			
R0.50	+/-0.030	.500	✓			
0.125	+/-0.010	.126	✓			
0.350	+/-0.010	.351	✓			
Ø0.250	+0.005/-0.001	.252	✓			
10°	+/-0.5°	10°	✓			
2.063	+/-0.010	2.063	✓			
Ø0.250	+0.005/-0.001	.252	✓			
1.00	+/-0.030	1.000				

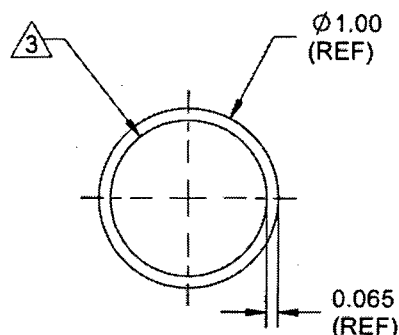
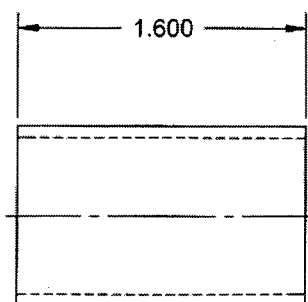
Measured by: RD	Audited by: SP	Prototype Approval:	N/A
Date: 08/08/29	Date: 08/08/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	DD

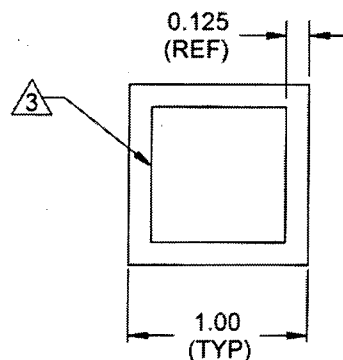
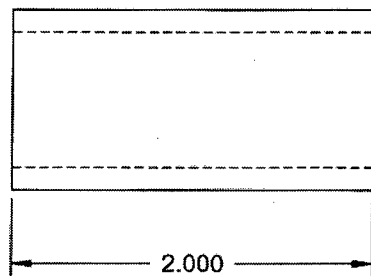
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 1 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED
05/08/18

**D3447-1 ROUND SPACER**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)

**D3447-3 SQUARE SPACER**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **41459**

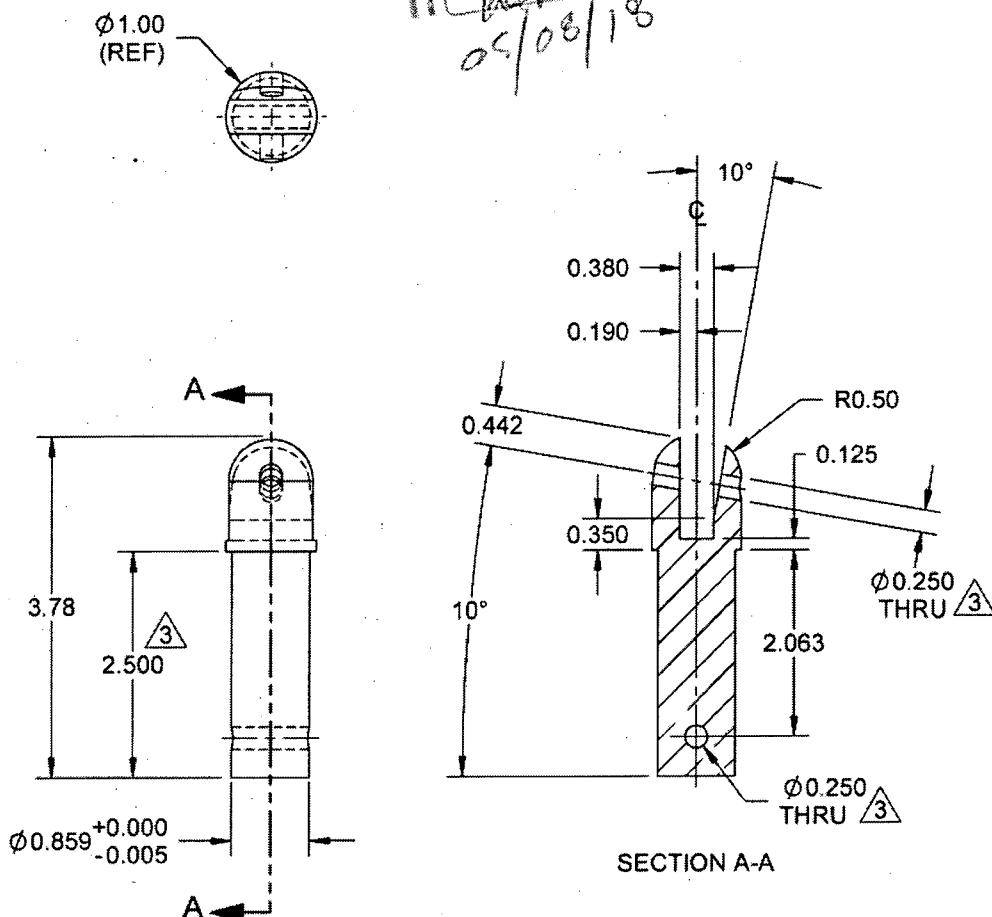
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

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[Signature]
05/08/18



D3447-5 CLEVIS
SUPERSEDES PREMIER P/N B67-43001-99

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

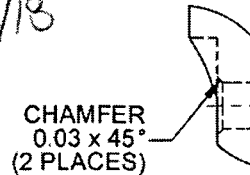
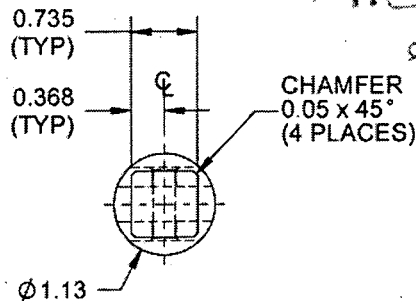
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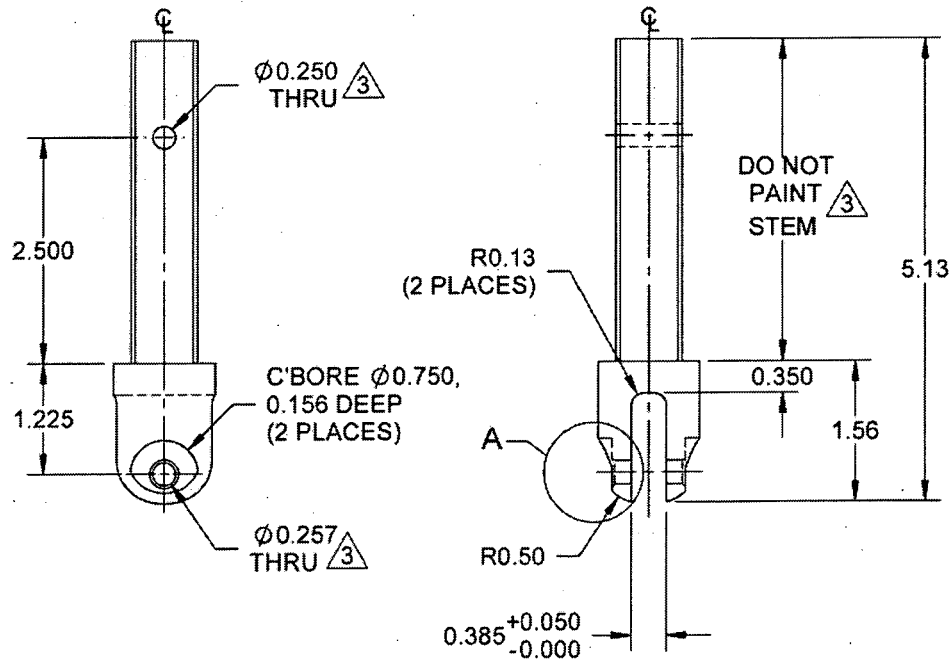
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2



DETAIL A
SCALE 1:1



D3447-7 CLEVIS
SUPERCEDES PREMIER P/N B67-43001-145/-345

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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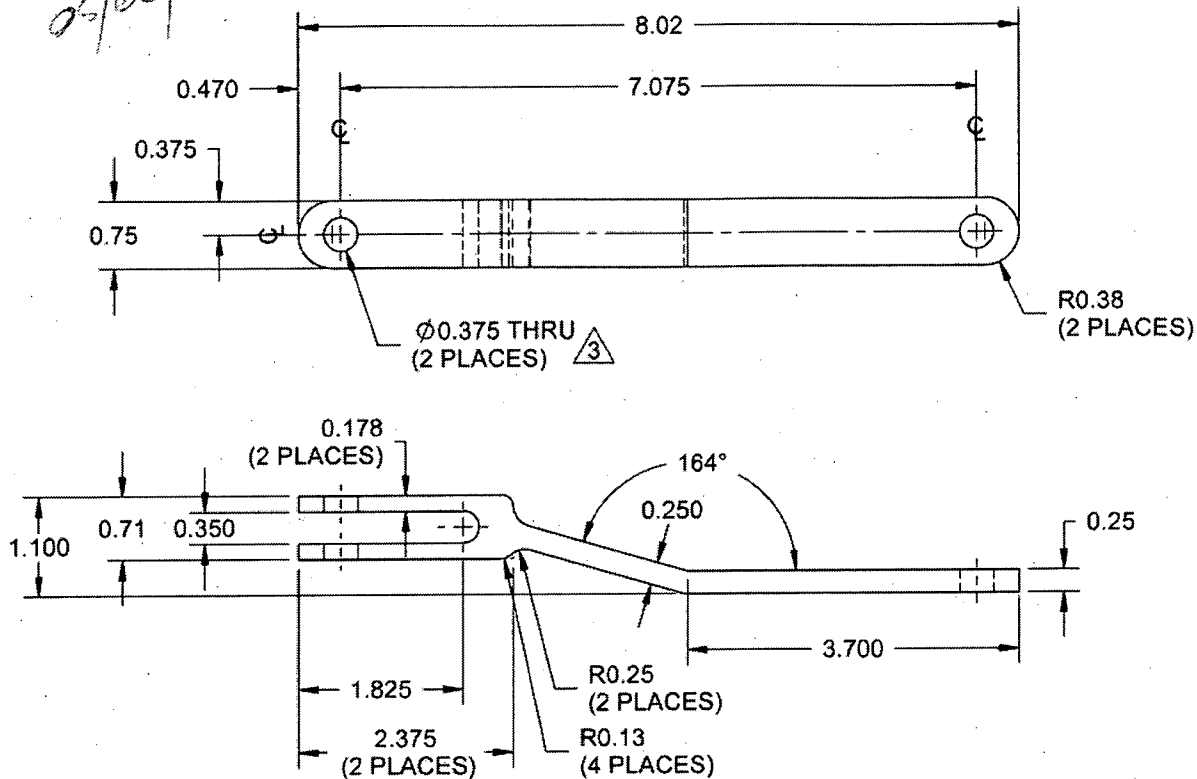
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

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05/08/18



D3447-9 SWING ARM
SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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